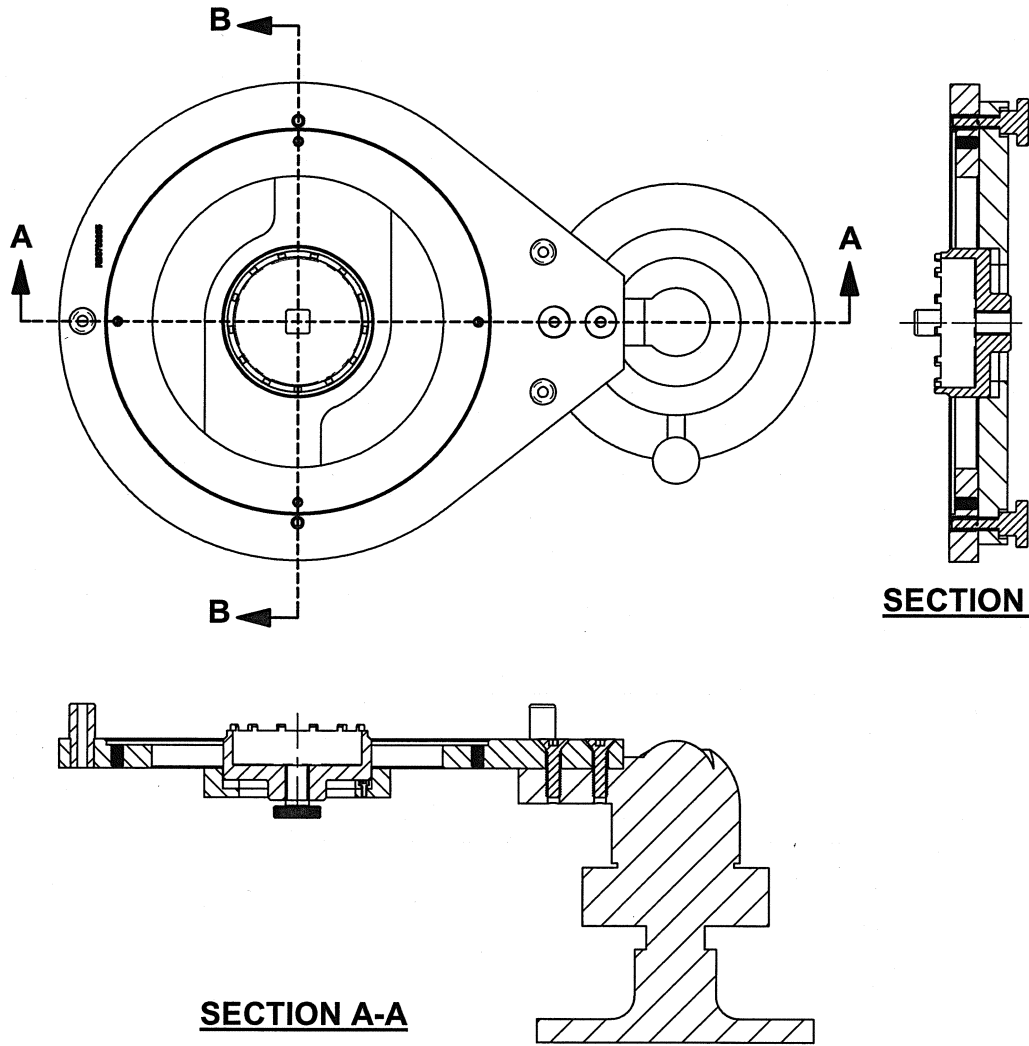
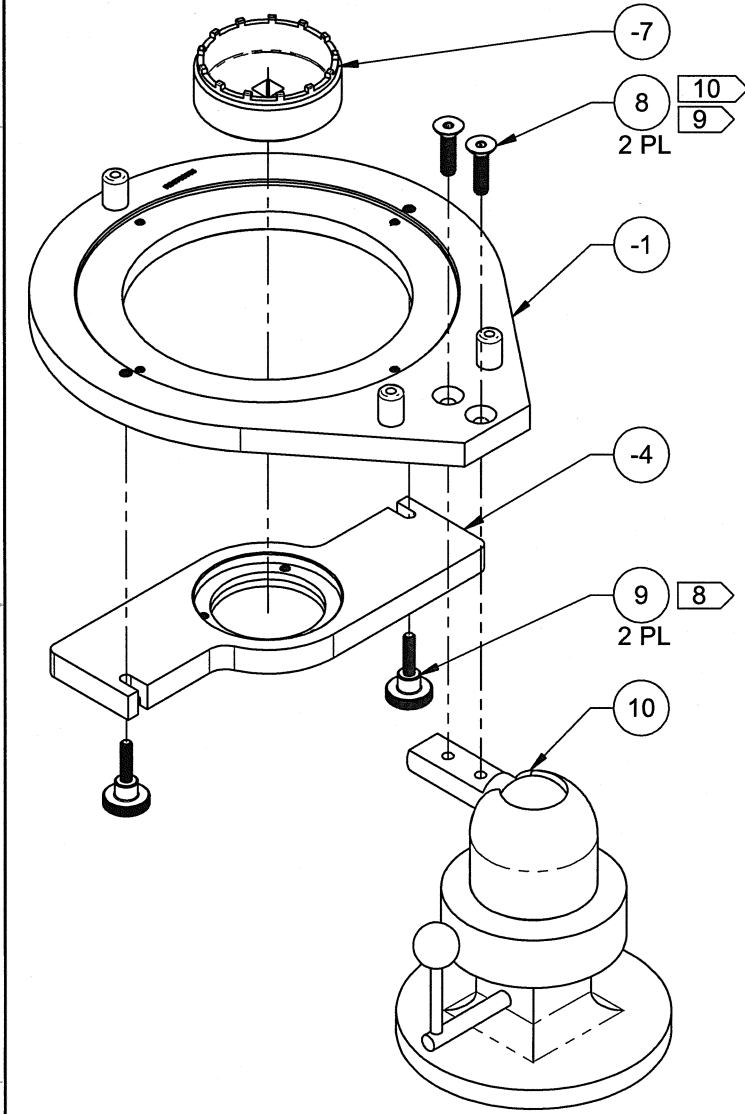
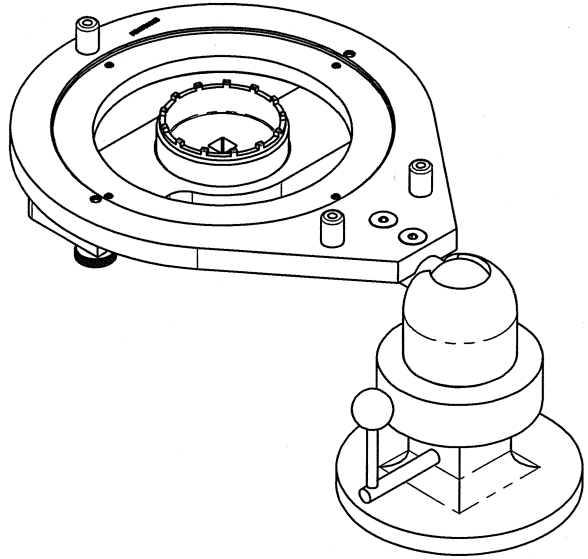


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6799955-1	PLATE ASSY
-4	1	RB6799955-4	WRENCH RETAINER ASSY
-7	1	RB6799955-7	WRENCH
8	2	McMaster#91263A731 OR EQUIV	ZINC PLATED STEEL HEX DRIVE FLAT HEAD SCREW 5/16"-18 X 1-1/4" LG.
9	2	McMaster#91882A429 OR EQUIV	BLACK OXIDE STEEL KNURLED-HEAD THUMB SCREW 1/4"-20 X 1" LG. X 1" DIA. HEAD
10	1	WILTON #301 OR EQUIV	STEEL POWER ARM TWO MOUNTING HOLES 5/16"-18 X 1" APART



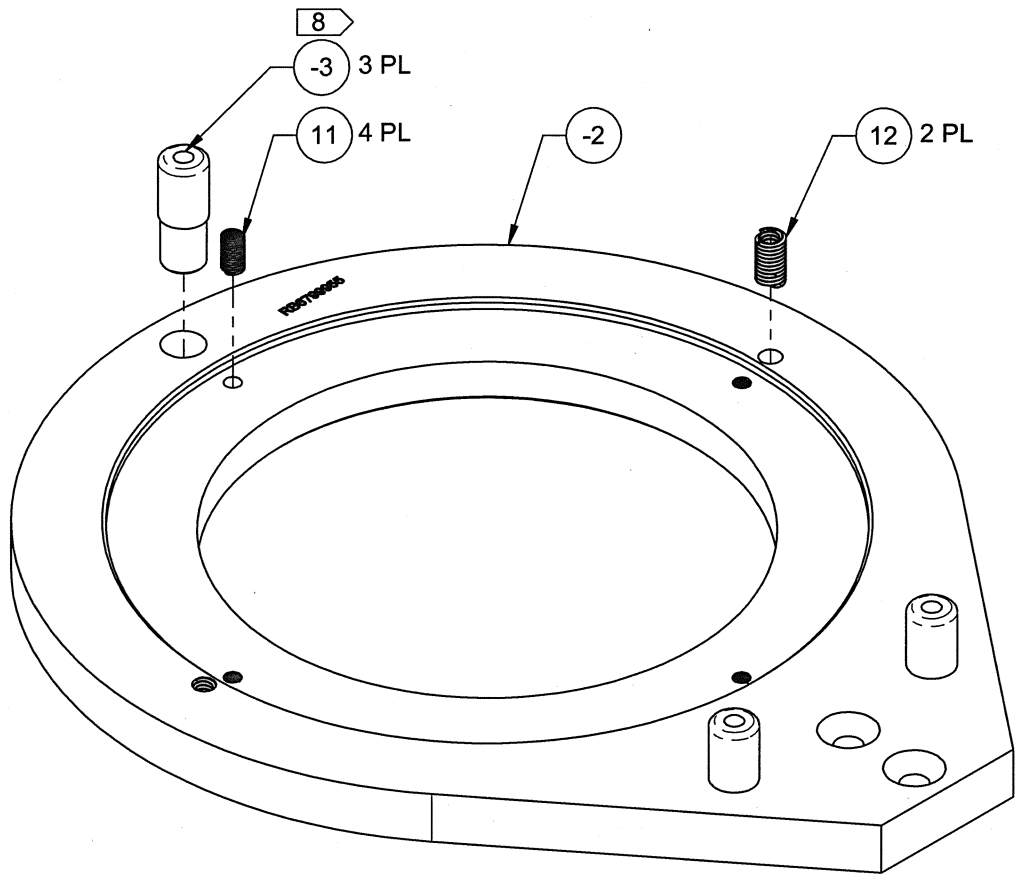
RB6799955 TURBINE FIXTURE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) INSTALL ITEM 9 HAND TIGHT
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 8 THEN ASSEMBLE WITH ITEM -1 AND ITEM 10, AND REMOVE EXCESS
 - 10) INSTALL ITEM 8 HAND TIGHT
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

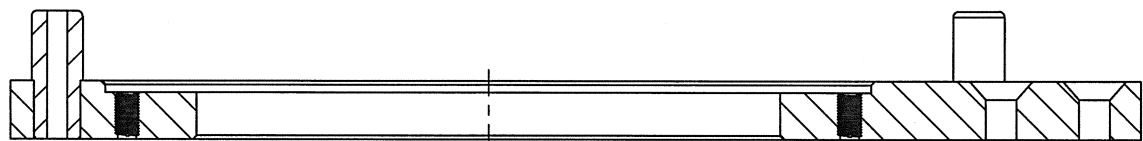
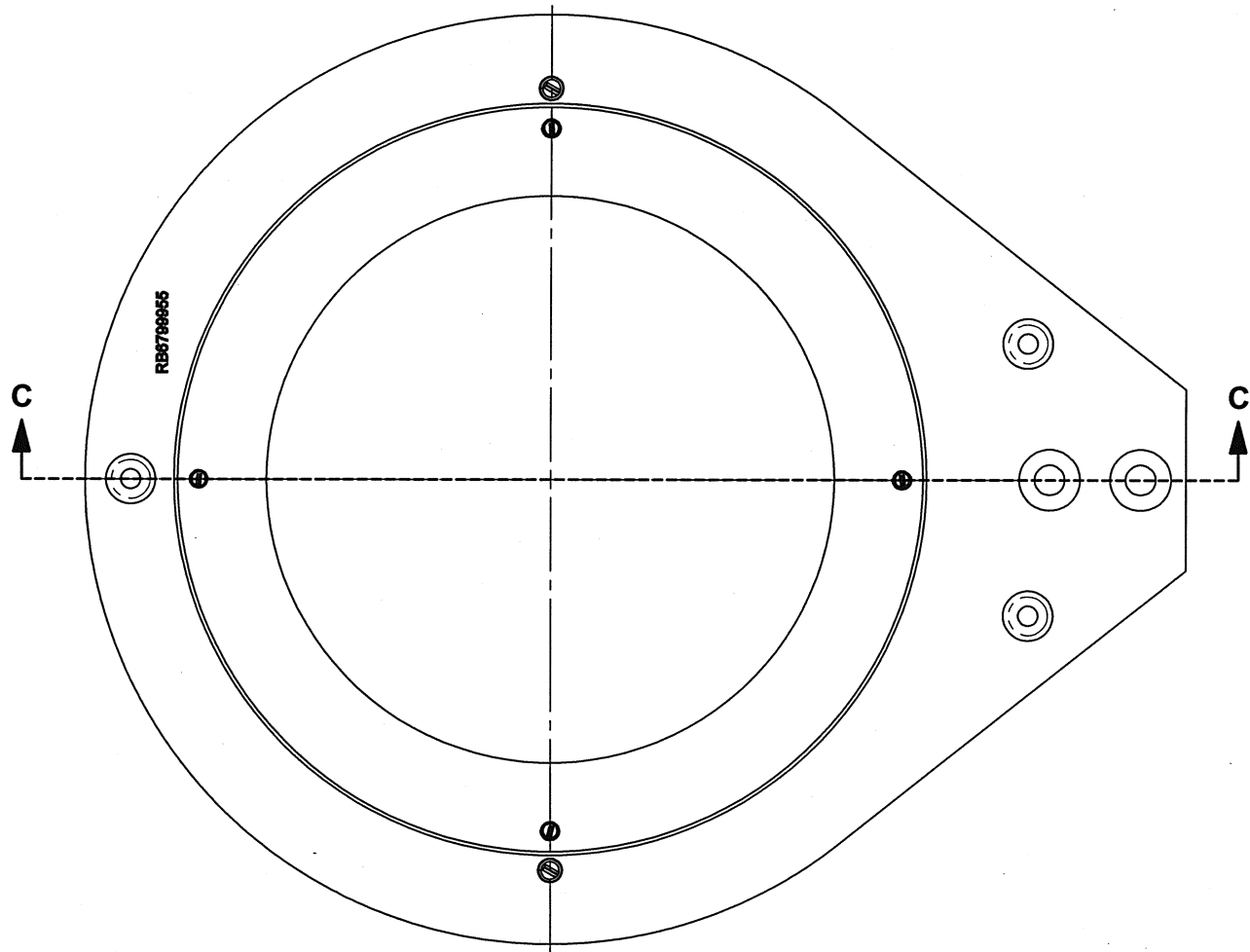
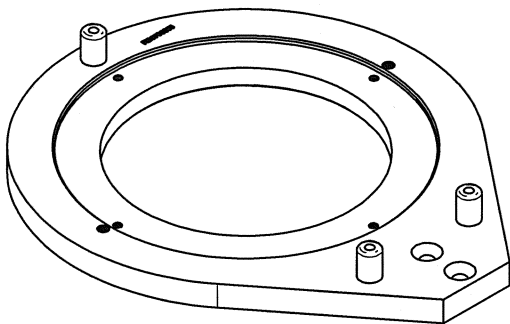


SEE PREVIOUS PDFs FOR OLDER REVs TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -1 CHANGED FOR ITEM -2 ITEM -2 McMaster#91253A585 CHANGED FOR ITEM 8 McMaster#91263A731 ITEM -3 CHANGED FOR ITEM 11 ITEM 12 McMaster#91732A735 ADDED ITEM -4 CHANGED FOR ITEM 10 ITEM -6 CHANGED FOR ITEM -5 ITEM -7 CHANGED FOR ITEM -6 ITEM -8 McMaster#91251A106 CHANGED FOR ITEM 13 McMaster#90128A106 ITEM -9 CHANGED FOR ITEM -7 ITEM -10 AND ITEM -11 REPLACE BY PURCHASE PART ITEM 9 McMaster#91882A429 ITEM -12 CHANGED FOR ITEM -3 ITEM -1 AND ITEM -4 ASSY ADDED ITEM -2 DIMENSION 4.625 +/- .002 REPLACED BY 9.887 +/- 0.001, DIMENSION 3X Ø .4981/.4971 CHANGED FOR Ø 0.5000/0.4992, DIMENSION 2X 1.500 +/- .002 REPLACED BY 3.000 +/- 0.001, DIMENSION 2X 1/4-20 UNC-2B CHANGED FOR TAP FOR 1/4-20 HELICOIL, DIMENSION 4.312 +/- .002 REPLACED BY 8.624, DIMENSION R5.13 CHANGED FOR Ø 10.25, ENGRAVING S/N AND "MADE IN USA" REMOVED, MATERIAL 6061 CHANGED FOR 6061-T6/7075-T6, FINISH CLEAR ANODIZE CHANGED FOR RED ANODIZE, DIMENSION 5.500 ADDED, DIMENSION 0.500 REMOVED, DIMENSION 1.00 REMOVED ITEM -3 MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 Rc), FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, DIMENSION .625 CHANGED FOR 0.625 +0/-0.005, DIMENSION R0.008 MAX ADDED, DIMENSION 0.03 X 45.0° CMF ADDED, DIMENSION Ø .550 CHANGED FOR Ø 0.550 +0/-0.005, DIMENSION Ø .4990/.4986 CHANGED FOR Ø 0.5008/0.5000 ITEM -5 MATERIAL 6061 FINISH CLEAR ANODIZE CHANGED FOR 6061-T6/7075-T6 FINISH RED ANODIZE, DIMENSION 4.312 +/- .002 REPLACED BY 8.624 +/- 0.001, DIMENSION 60.0° ADDED, DIMENSION 2X L .625 +.002/-0 .19 CHANGED FOR Ø 0.63, DIMENSION 2X .31 CHANGED FOR 0.281 2 PL, DIMENSION R0.008 MAX ADDED, DIMENSION 2.50 2 PL ADDED, DIMENSION 0.03 x 45.0° CMF ADDED ITEM -6 MATERIAL DOM CHANGED FOR A36/1018/1020/1025 HR, FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, DIMENSION 120.0° 2 PL ADDED ITEM -7 MATERIAL 4140/4142 RC 32-36 CHANGED FOR O1 48-52 Rc, DIMENSION 27.7° 12 PL ADDED, DIMENSION R0.03 ADDED, DIMENSION Ø 2.780/2.770 CHANGED FOR Ø 2.775, DIMENSION Ø 3.190/3.180 CHANGED FOR Ø 3.185		19-753	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 1 OF 8
APPROVED	W	TITLE	SCALE
DATE 2019-06-26		TURBINE FIXTURE ASSEMBLY	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB6799955-2	PLATE
-3	3	RB6799955-3	LOCATOR
11	4	McMaster#91732A726 OR EQUIV	18-8 SS HELICAL INSERT #10-32 X 0.475" LG.
12	2	McMaster#91732A735 OR EQUIV.	18-8 SS HELICAL INSERT 1/4"-20 X 5/8" LG.



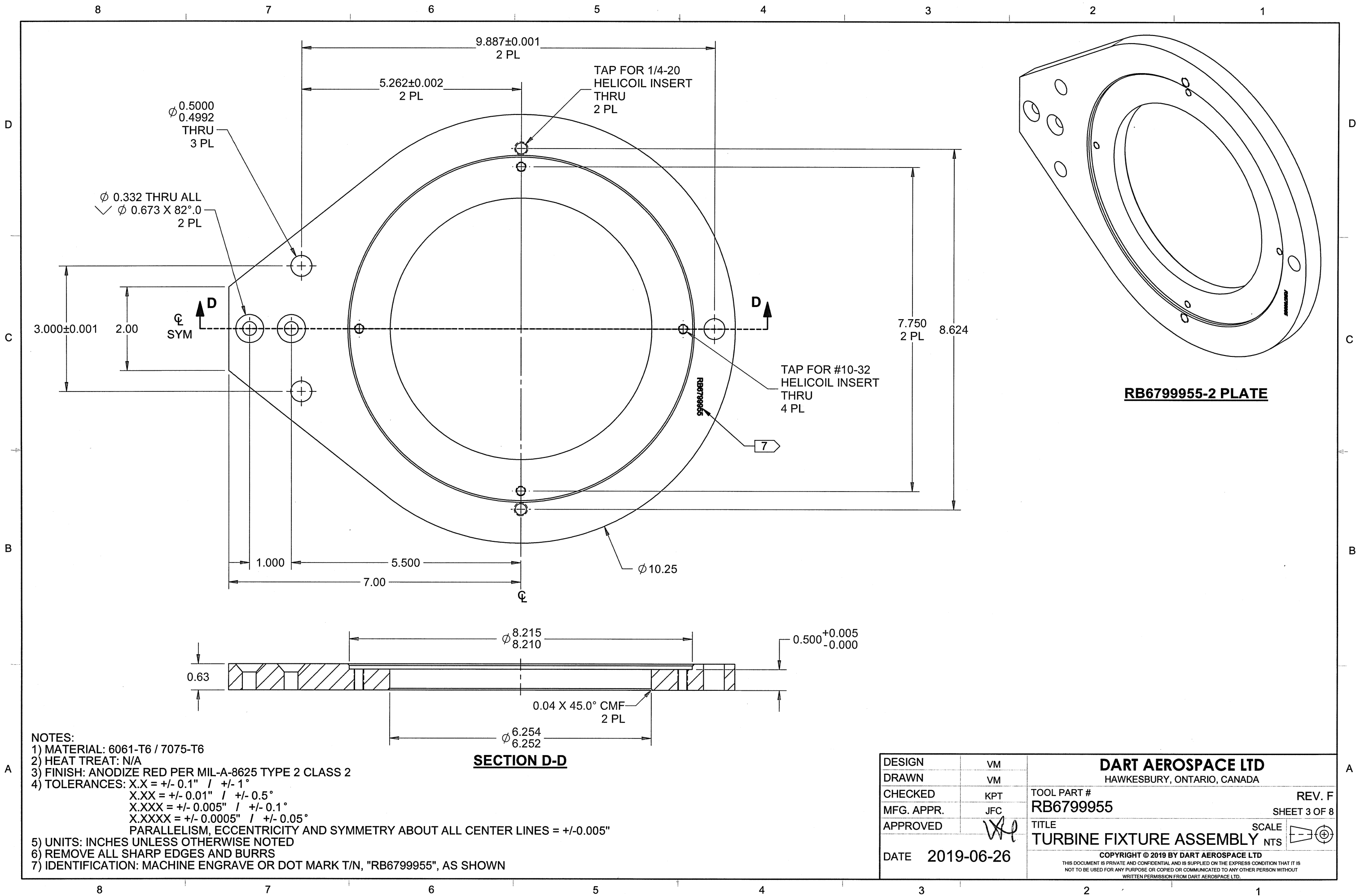
RB6799955-1 PLATE ASSY



SECTION C-C

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 WITH ITEM -2, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DATE	2019-06-26	TURBINE FIXTURE ASSEMBLY	NTS
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NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6799955", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DATE	2019-06-26	TURBINE FIXTURE ASSEMBLY	NTS
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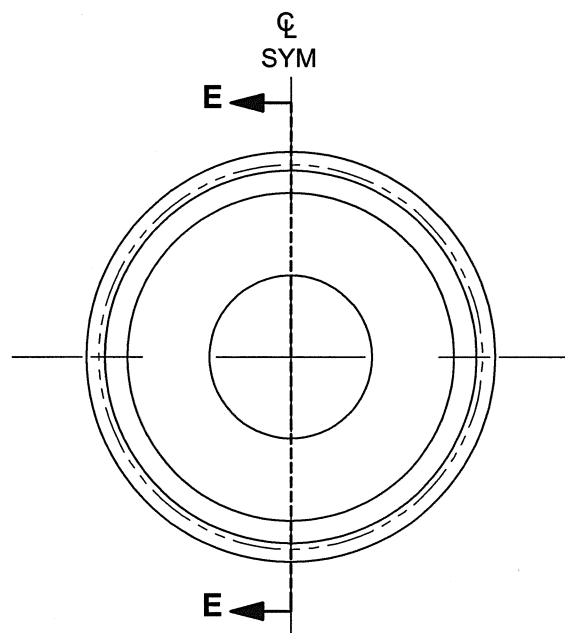
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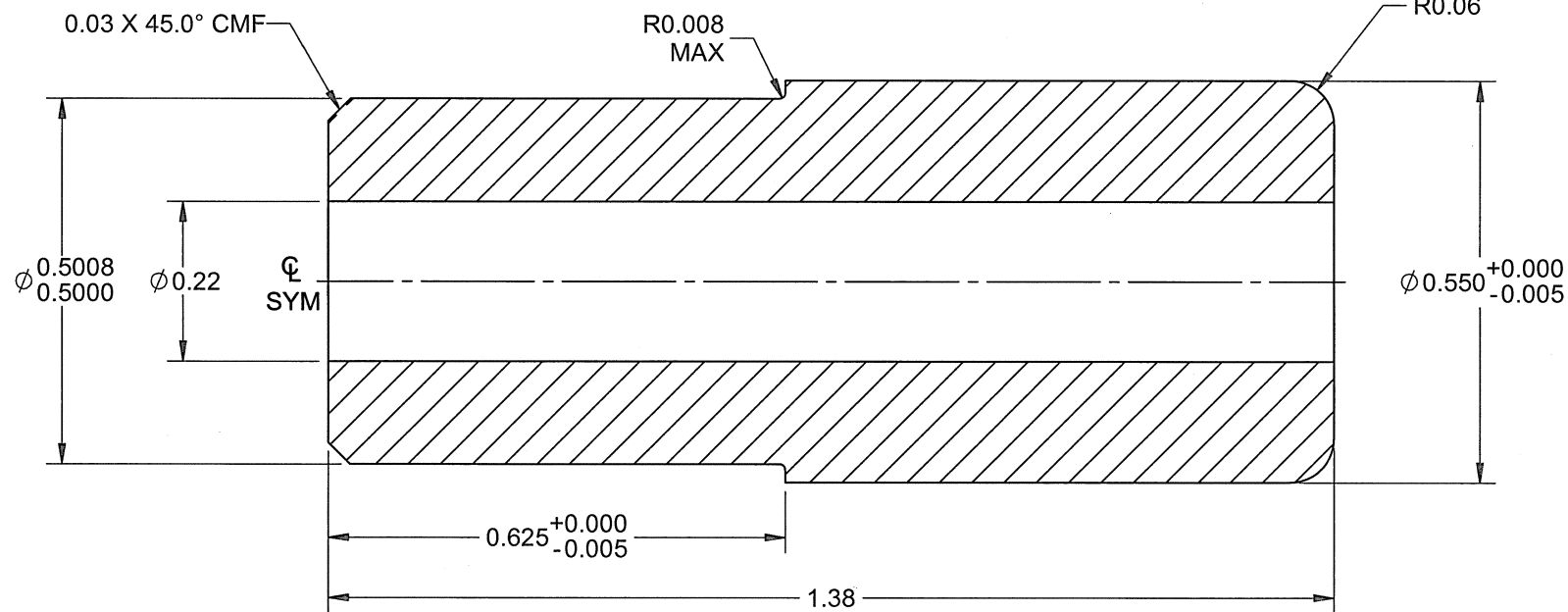
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**RB6799955-3 LOCATOR**

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**SECTION E-E****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART # RB6799955	REV. F
MFG. APPR.	JFC		SHEET 4 OF 8
APPROVED		TITLE TURBINE FIXTURE ASSEMBLY	SCALE NTS
DATE 2019-06-26		COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

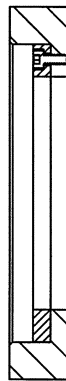
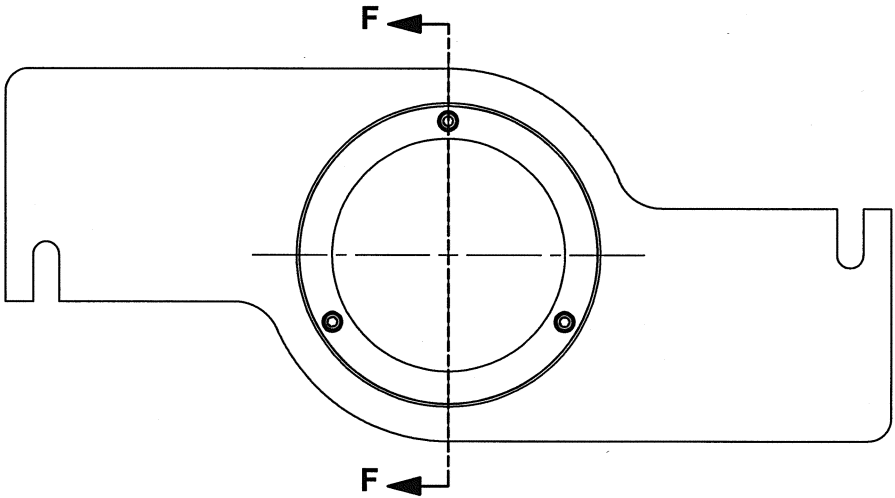
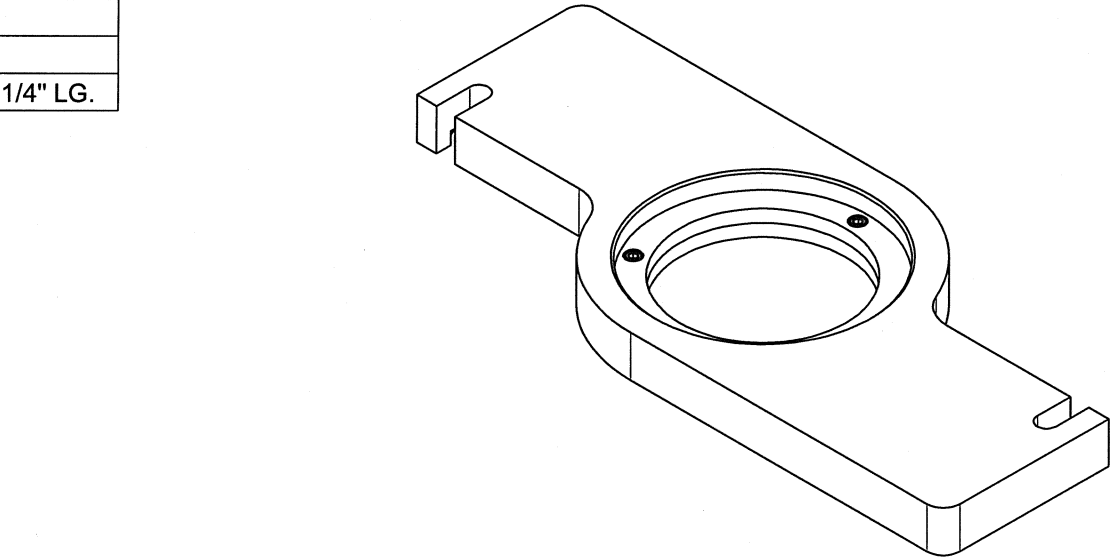
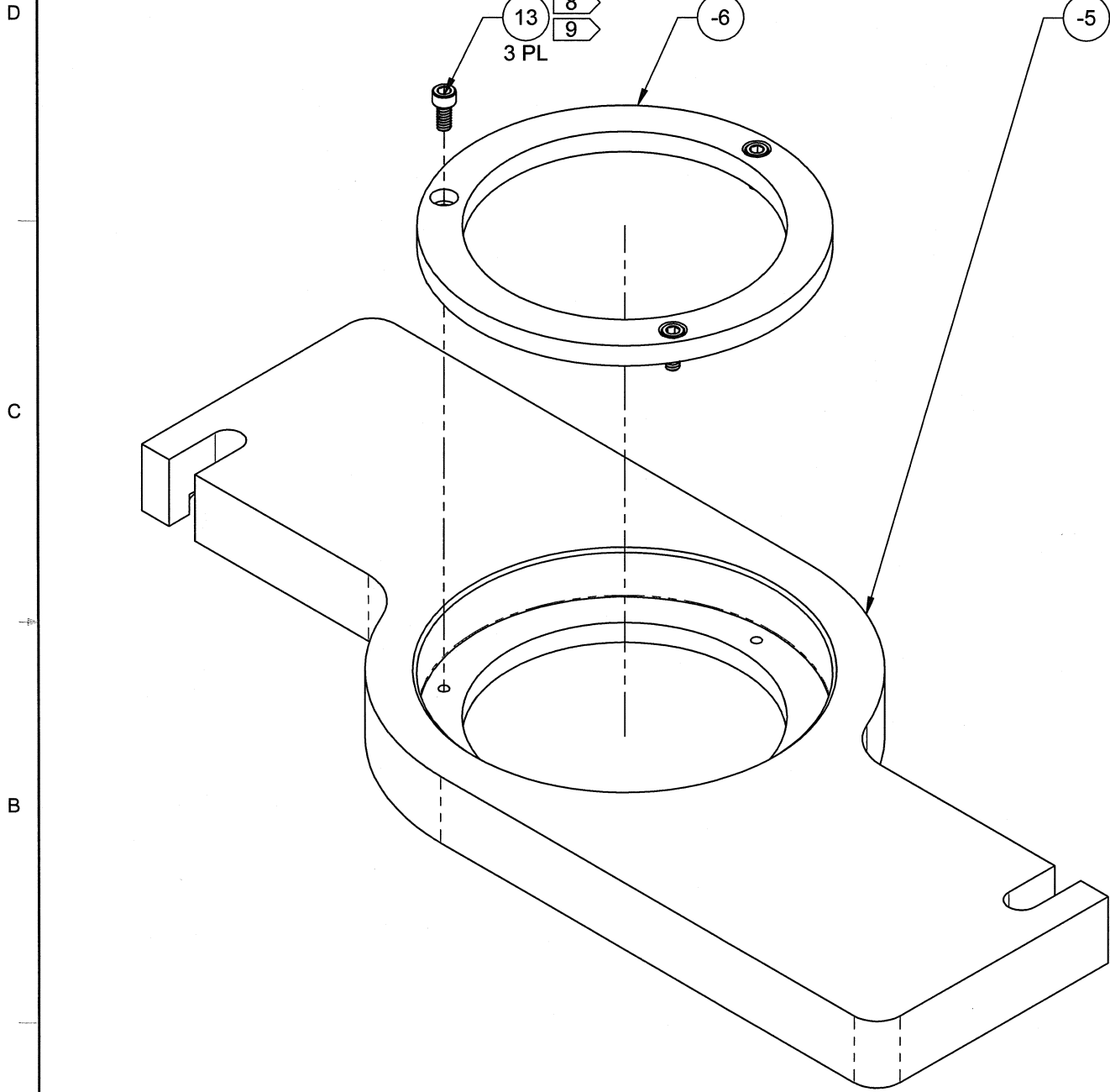
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB6799955-5	WRENCH RETAINER PLATE
-6	1	RB6799955-6	SPACER
13	3	McMaster#90128A106 OR EQUIV	ZINC PLATED STEEL SOCKET HEAD CAP SCREW #4-40 X 1/4" LG.

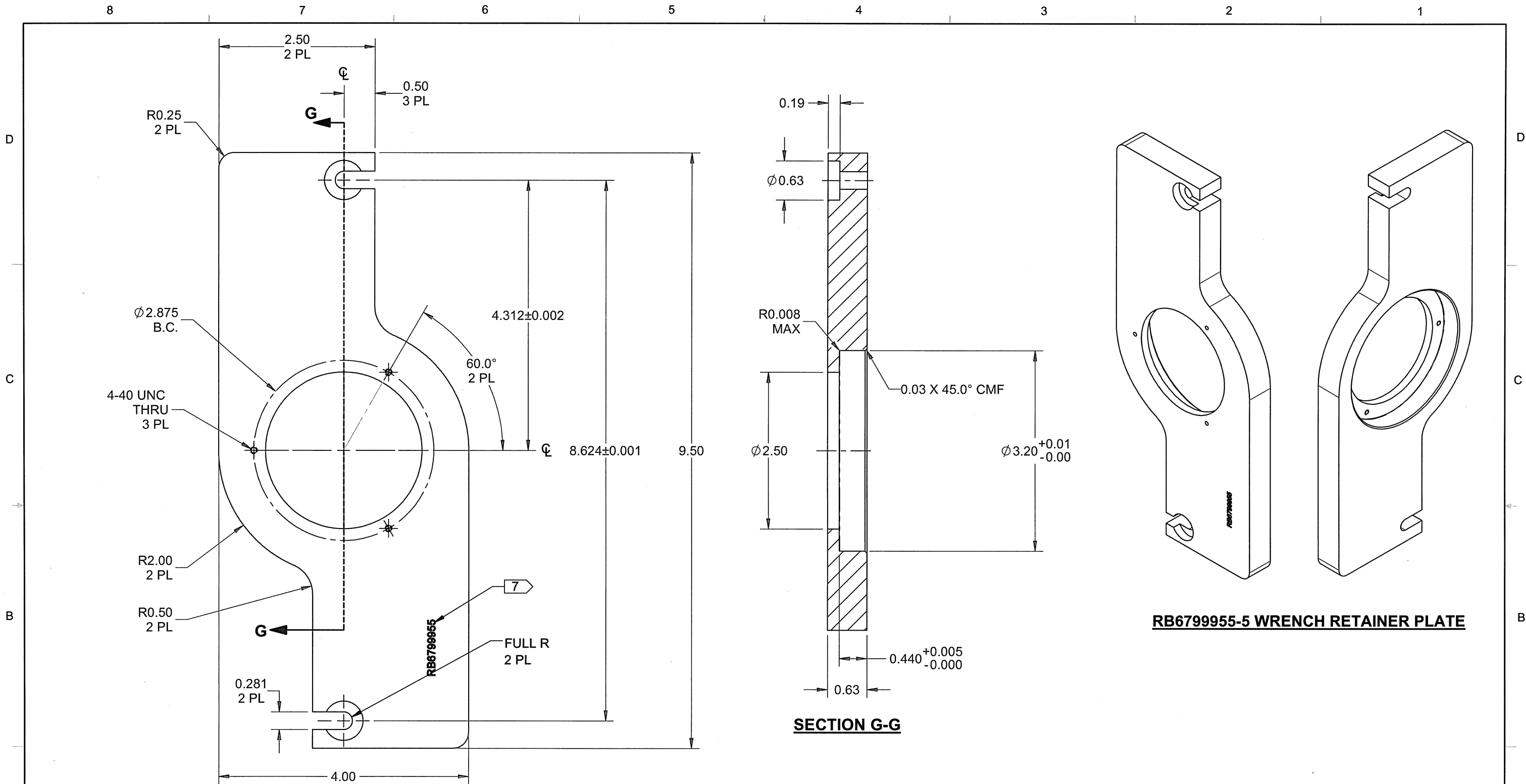


SECTION F-F

RB6799955-4 WRENCH RETAINER ASSY

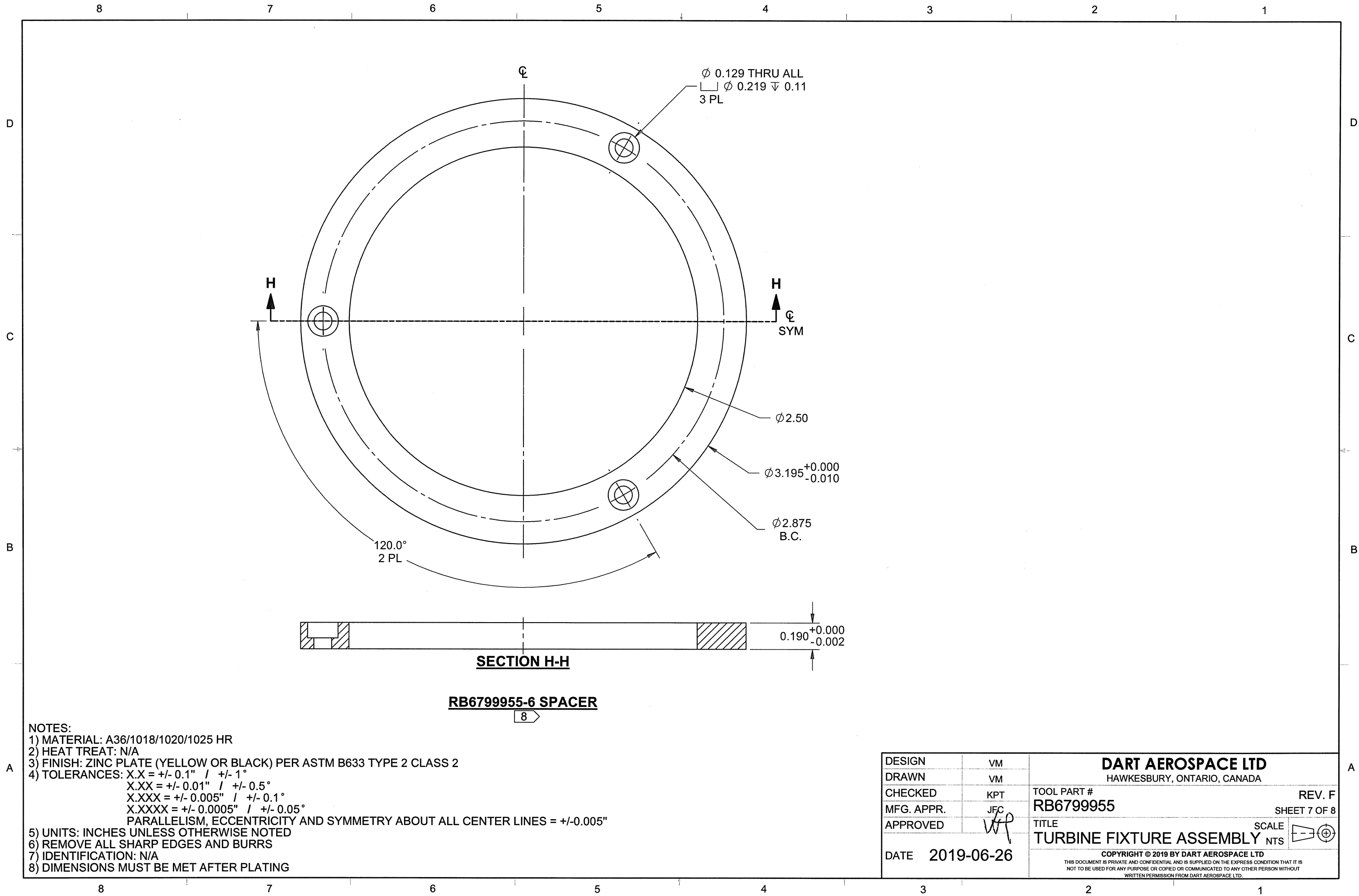
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 13 THEN ASSEMBLE WITH ITEM -6 AND ITEM -5, AND REMOVE EXCESS
 - 9) INSTALL ITEM 13 HAND TIGHT

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DATE	2019-06-26	TURBINE FIXTURE ASSEMBLY	NTS
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NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6799955", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 2019-06-26		TURBINE FIXTURE ASSEMBLY	NTS
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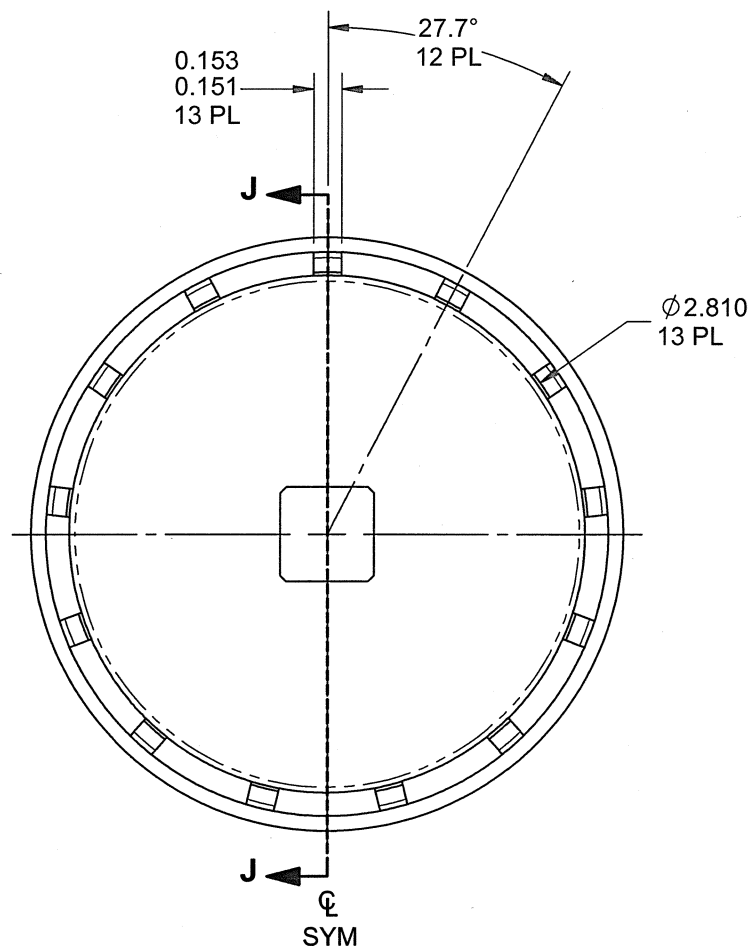
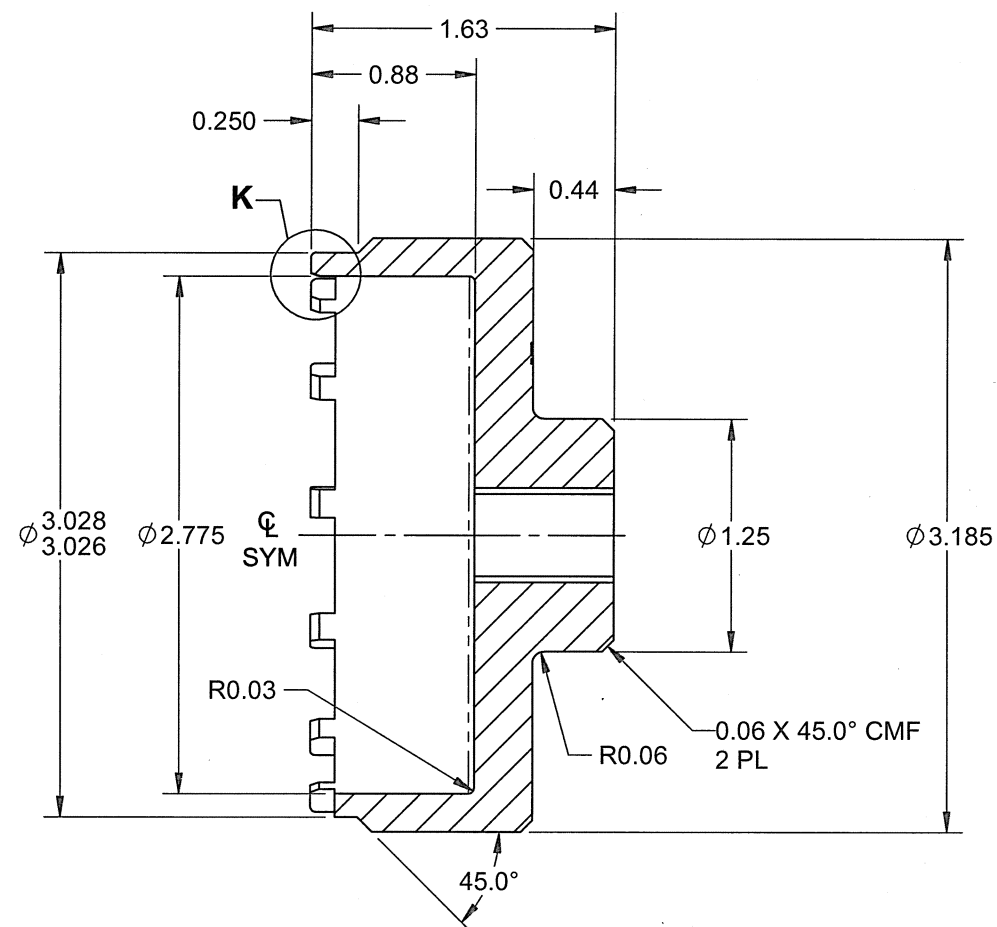
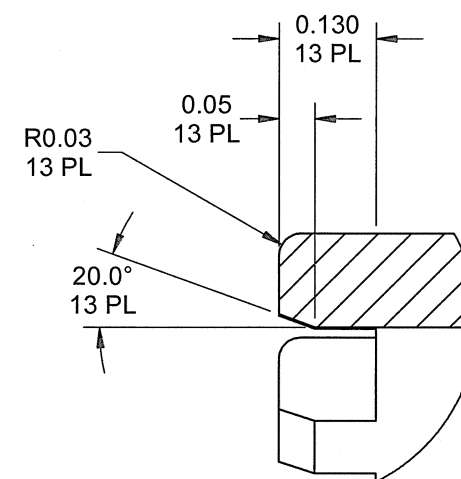
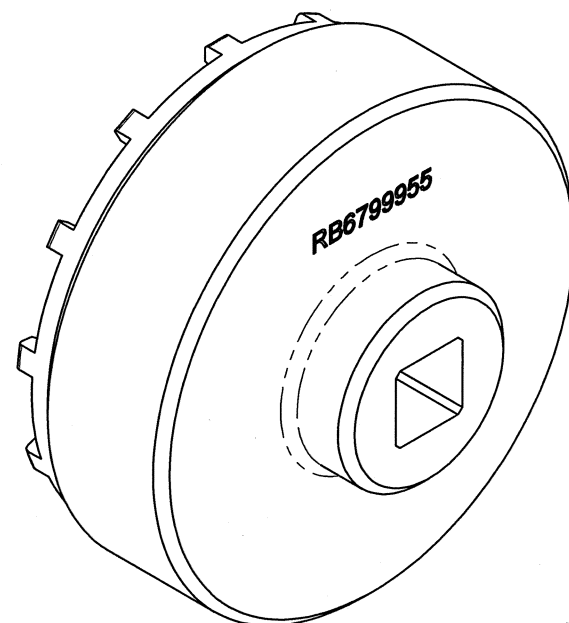
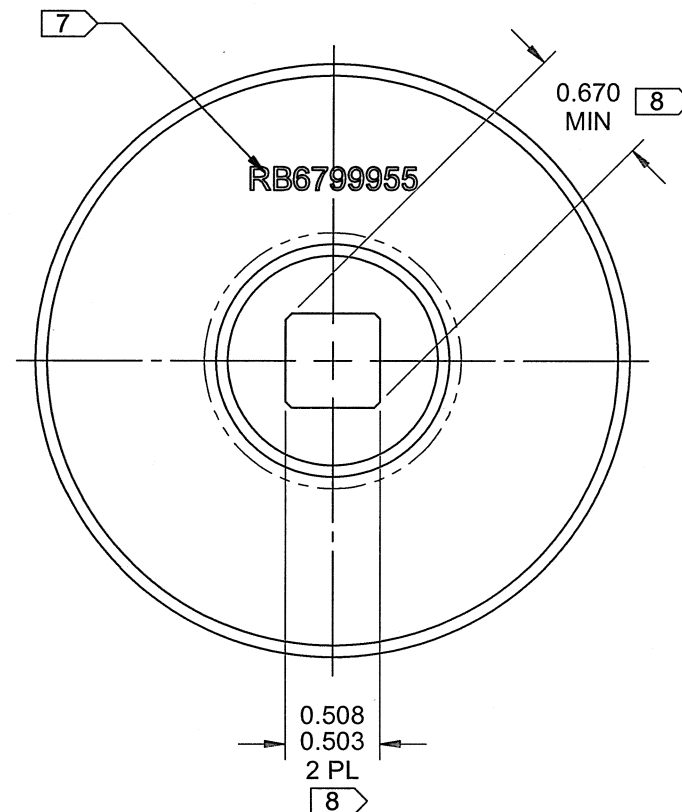
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**RB6799955-7 WRENCH****SECTION J-J****DETAIL K****NOTES:**

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6799955", AS SHOWN
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DATE 2019-06-26		TURBINE FIXTURE ASSEMBLY	NTS
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